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April-13-15 10:23:01 AM

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Draw Nbr	Revision Nbr
D3622	Rev C

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo	0.00
-------------	-------------

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622 ,

FOLIO REV: *AD.*

DWG REV: C

2-DEBURR AS REQUIRED

DAS

37

9-89 15.04.18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS

37

9-89 15-04-18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

40

9-88

15/04/19

Work Order ID 131523

131523

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Item ID: D3622-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ball Stud
 Start Date: 4/13/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 4/17/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>st</i>	0.00				<i>30</i>			
130						<i>DAS</i>			
Packaging	Memo	0.00				<i>27</i>			
Packaging						<i>9-00</i>			
						<i>APR 21 2015</i>			
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-21

MLJ 15-04-21

Picklist Print

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Work Order ID: 131523

131523

Parent Item: D3622-1

D3622-1

Parent Item Name: Ball Stud

Start Date: 4/13/15

Required Date: 4/17/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	5.5900	0.108	4			DAS
M303H0 500									**				37
303 HEX BAR .500													989

15.04.18

Location

Loc Qty

Loc Code

MAT018

5.59

m128882

5.59

496.

DART AEROSPACE LTD		Work Order:	31523
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1	

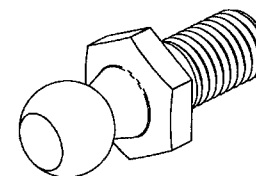
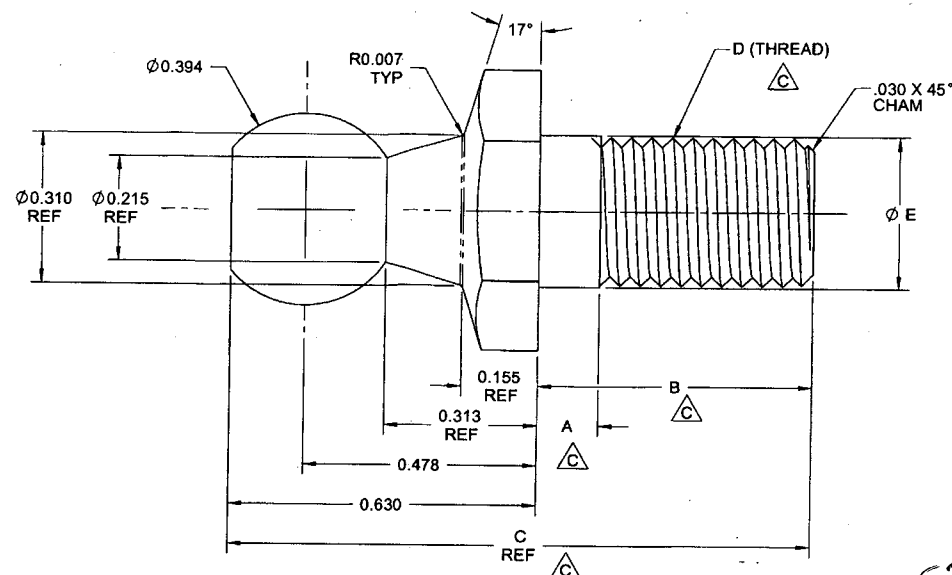
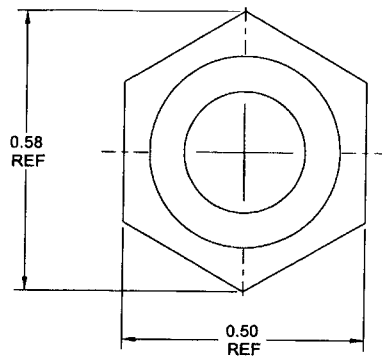
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

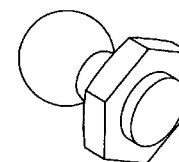
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	.580	✓		DK 16	8" VERN
0.50	+/-0.030	.500	✓			
Ø0.394	+/-0.010	.393	✓			
Ø0.310	+/-0.010	.308	✓			
Ø0.215	+/-0.010	.212	✓			
0.155	+/-0.010	.154	✓			
0.313	+/-0.010	.3125	✓			
0.478	+/-0.010	.478	✓			
0.630	+/-0.010	.634	✓			
0.125	+/-0.010	.125	✓			
0.563	+/-0.010	.560	✓			
1.19	+/-0.030	1.189	✓			
0.3125-24UNF-3A	+0.000/-0.072	.309	✓			
M.O.W.	Min = 0.3336 Max = 0.3363	.335	✓			

Measured by: DAS 37 Date: 15/04/18		Audited by: DAS 40 Date: 15/04/19		Preliminary Approval: 9-89 Date:	
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Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	



**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E	
						MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3622	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	